



Dart Aerospace Ltd.
1270 Aberdeen St
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D2649
Job Sheet 200434



Part No: D2649

Job Qty: 60 pcs **DAS**
69 **21**
9-89

Part Name: Cross Bolt Spacer



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/11/19

Job Tracking No:

Due Date: 10/2/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B1 IPP F 02.03.26 Added turning on Cobra NG IPP Rev:G 10.05.11 added cleaning DD verified :EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
100	Hardinge - 1	60 pcs	10/2/19	10/2/19	0.50	0.77	Hardinge - 1		BM 19-10-28
120	QC 8	60 pcs	10/2/19	10/2/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		J.C.L. 19-10-29
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		
150	QC 6	60 pcs	10/2/19	10/2/19	0.00	0.00	QC 6 - 9		DAS
							QC 6 - 68		OCT 31 2019 68
							QC 6 - 61		9-89



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Container No: S227234



Part: D2649

Job No: 200434

Serial No/Batch: S227234

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/28/19

				QC 6 - 40	
				QC 6 - 81	
160 Packaging 3-1 - Stock - B4B 60 pcs	10/2/19	0.00 0.00	Packaging 3 - 1 - B4B		
			Packaging 3 - 2 - B4B		
			Packaging 3 - 3 - B4B		
			Packaging 3 - 4 - B4B		
			Packaging 3 - 5 - B4B		
			Packaging 3 - 6 - B4B		
			Packaging 3 - 7 - B4B		
			Packaging 3 - 8 - B4B		
			Packaging 3 - 9 - B4B		
			Packaging 3 - 10 - B4B		
			Packaging 3 - 11 - B4B		
			Packaging 3 - 12 - B4B		
			Packaging 3 - 13 - B4B		
			Packaging 3 - 14 - B4B		
			Packaging 3 - 15 - B4B		
			Packaging 3 - 16 - B4B		
			Packaging 3 - 17 - B4B		
			Packaging 3 - 18 - B4B		
			Packaging 3 - 19 - B4B		
			Packaging 3 - 20 - B4B		
			Packaging 3 - 21 - B4B		
			Packaging 3 - 22 - B4B		
			Packaging 3 - 23 - B4B		
			Packaging 3 - 24 - B4B		
			Packaging 3 - 25 - B4B		
			Packaging 3 - 26 - B4B		55
			Packaging 3 - 27 - B4B		
			Packaging 3 - 28 - B4B		
			Packaging 3 - 29 - B4B		
			Packaging 3 - 30 - B4B		
			Packaging 3 - 31 - B4B		
			Packaging 3 - 32 - B4B		
			Packaging 3 - 33 - B4B		
			Packaging 3 - 34 - B4B		
			Packaging 3 - 35 - B4B		
			Packaging 3 - 36 - B4B		
170 QC 21 - SA 60 pcs	10/2/19	0.00 0.00	QC 21 - SA - 21	55	NOV 05 2019
			QC 21 - SA - 70	21	
			QC 21 - SA - 53	53	

Part Op 100 - Hardinge - Machine as per folio FA214 on cobra machine.

Descriptions: 120 - QC8- Inspect parts - second check

150 - QC6- All purchased or subcontracted products

160 - Identify as per dwg & Stock Location: LG004 ***STOCK IN SKIDTUBE CELL*** LOCATION :LG001

170 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6T0.375W.058	6061-T6 Round Tube .375 X.058W	16.9980 ft (.2833 ea)	100-Hardinge - 1	5219899

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Hardinge - 1	M6061T6T0.375W.058	17	60	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Crossbolt Spacer	3.180Inches + 0.030 - 0.000	3.210 3.180	3.204	
2	Crossbolt Spacer	0.375Inches ± 0.010	0.385 0.365	0.375	
3	Crossbolt Spacer	0.025Inches + 0.005 - 0.000	0.030 0.025	0.029	

Plex 9/11/19 11:28 AM Dart.lajeunesse.marie

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No.

Job: _____ Part No. _____		DISPOSITION		DEPARTMENT/PROCESS							
Date :	Sequence #:	Rework Scrap Use-as-is		Skid-tube Machining Large Fab		Cross tube Small Fab Finishing		Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging		Engineering Water Jet Supplier Quality	
										MRB (Q51042)	
Description Work Order Deviation		Disposition								Completed By	
										Lead hand / Supervisor	
										QC / QA Coordinator	
Root Cause		FAULT CATEGORY							Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread		
Operator		Pressure/Forced		Contamination		Power Loss/Surge					
Manufacturing Process		Bending		Misaligned/off center		Folio/Program					
Equip/Tooling		Crushing		BOM/Route		Grain Direction					
Handling/Preservation		Cracks		Broken/Damage/Defect		Weld					
Material		Crimp/kink/Ripple/Wave/Twist		Incomplete/Unclear Instructions		Wrong Stock Pulled					
Product Improvement		Marks/Chatter		Drill Holes		Out of Sequence					
Process Improvement		Mislabeled		Fit/Function		Off-set/Set-up					
Human Factors		Other/Details:									